



## INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

<b>(51) International Patent Classification <sup>6</sup> :</b> <b>C07D 309/30, C07C 235/26, 235/30,</b> <b>C07D 319/06, 327/10, C07F 9/6574</b>	<b>A1</b>	<b>(11) International Publication Number:</b> <b>WO 98/32751</b> <b>(43) International Publication Date:</b> 30 July 1998 (30.07.98)
<b>(21) International Application Number:</b> PCT/EP98/00519 <b>(22) International Filing Date:</b> 27 January 1998 (27.01.98) <b>(30) Priority Data:</b> 97200223.2 28 January 1997 (28.01.97) EP <b>(34) Countries for which the regional or international application was filed:</b> AT et al. 97306809.1 3 September 1997 (03.09.97) EP <b>(34) Countries for which the regional or international application was filed:</b> AT et al. <b>(71) Applicant (for all designated States except US):</b> GIST-BROCADES B.V. [NL/NL]; Wateringseweg 1, P.O. Box 1, NL-2600 MA Delft (NL). <b>(72) Inventors; and</b> <b>(75) Inventors/Applicants (for US only):</b> VRIES, Ton, René [NL/NL]; Anna Palownastraat 24, NL-9725 JT Groningen (NL). WJNBÉRG, Hans [NL/NL]; Nijenborgh 4, NL-9747 AG Groningen (NL). FABER, Wijnand, Sjouerd [NL/NL]; Laan van de Vrede 76, NL-9728 CD Groningen (NL). KALKMAN-AGAYN, Venetka, Ivanova [NL/NL]; Ruychrocklaan 68, NL-2597 EP Den Haag (NL). SIBEYN, Mieke [NL/NL]; Pauwstraat 8, NL-3816 AV Amersfoort (NL).	<b>(74) Agents:</b> VISSER-LUIRINK, Gesina et al.; Gist-Brocades N.V., Patents and Trademarks Dept., Wateringseweg 1, P.O. Box 1, NL-2600 MA Delft (NL). <b>(81) Designated States:</b> AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, CA, CH, CN, CU, CZ, DE, DK, EE, ES, FI, GB, GE, GH, GM, GW, HU, ID, IL, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MD, MG, MK, MN, MW, MX, NO, NZ, PL, PT, RO, RU, SD, SE, SG, SI, SK, SL, TJ, TM, TR, TT, UA, UG, US, UZ, VN, YU, ZW, ARIPO patent (GH, GM, KE, LS, MW, SD, SZ, UG, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, ML, MR, NE, SN, TD, TG). <b>Published</b> With international search report.	
<b>(54) Title:</b> PROCESS FOR THE PRODUCTION OF SEMI SYNTHETIC STATINS VIA NOVEL INTERMEDIATES		
<b>(57) Abstract</b>		
<p>A process has been provided to produce semi synthetic statins, as for instance simvastatin with a high yield, from another statin, preferably a naturally occurring statin, as for instance lovastatin. Also a number of novel intermediate compounds, prepared during said process, has been provided.</p>		

**FOR THE PURPOSES OF INFORMATION ONLY**

Codes used to identify States party to the PCT on the front pages of pamphlets publishing international applications under the PCT.

AL	Albania	ES	Spain	LS	Lesotho	SI	Slovenia
AM	Armenia	FI	Finland	LT	Lithuania	SK	Slovakia
AT	Austria	FR	France	LU	Luxembourg	SN	Senegal
AU	Australia	GA	Gabon	LV	Latvia	SZ	Swaziland
AZ	Azerbaijan	GB	United Kingdom	MC	Monaco	TD	Chad
BA	Bosnia and Herzegovina	GE	Georgia	MD	Republic of Moldova	TG	Togo
BB	Barbados	GH	Ghana	MG	Madagascar	TJ	Tajikistan
BE	Belgium	GN	Guinea	MK	The former Yugoslav Republic of Macedonia	TM	Turkmenistan
BF	Burkina Faso	GR	Greece			TR	Turkey
BG	Bulgaria	HU	Hungary	ML	Mali	TT	Trinidad and Tobago
BJ	Benin	IE	Ireland	MN	Mongolia	UA	Ukraine
BR	Brazil	IL	Israel	MR	Mauritania	UG	Uganda
BY	Belarus	IS	Iceland	MW	Malawi	US	United States of America
CA	Canada	IT	Italy	MX	Mexico	UZ	Uzbekistan
CF	Central African Republic	JP	Japan	NE	Niger	VN	Viet Nam
CG	Congo	KE	Kenya	NL	Netherlands	YU	Yugoslavia
CH	Switzerland	KG	Kyrgyzstan	NO	Norway	ZW	Zimbabwe
CI	Côte d'Ivoire	KP	Democratic People's Republic of Korea	NZ	New Zealand		
CM	Cameroon	KR	Republic of Korea	PL	Poland		
CN	China	KZ	Kazakhstan	PT	Portugal		
CU	Cuba	LC	Saint Lucia	RO	Romania		
CZ	Czech Republic	LI	Liechtenstein	RU	Russian Federation		
DE	Germany	LK	Sri Lanka	SD	Sudan		
DK	Denmark	LR	Liberia	SE	Sweden		
EE	Estonia			SG	Singapore		

PROCESS FOR THE PRODUCTION OF SEMI SYNTHETIC STATINS  
VIA NOVEL INTERMEDIATES

FIELD AND BACKGROUND OF THE INVENTION

5

The present invention relates to a process to prepare semi synthetic statines and to intermediates formed during said process.

It is well known that certain mevalonate derivatives are active  
10 as hypercholesterolemic agents, which function by limiting the cholesterol biosynthesis by inhibiting the enzyme HMG-CoA reductase. These mevalonate derivatives are the naturally occurring fungal metabolites lovastatin and compactin. But also semi-synthetic and synthetic analogs thereof are active.

15 The naturally occurring compounds lovastatin and compactin possess a 2-methylbutyrate side chain in the 8-position of the hexahydronaphtalene ring system. Analogs with a 2,2-dimethylbutyrate moiety in this position, such as simvastatin, appeared to be more effective inhibitors of HMG-CoA  
20 reductase.

These compounds can be synthesized from the naturally occurring compounds. In principle there are two possible routes for the introduction of an extra  $\alpha$ -methyl group in the 8-acyl side chain which are:

- 25 1. direct alkylation of the 2-methylbutyrate side chain,  
2. removal of the 2-methylbutyrate side chain and introduction of a 2,2-dimethyl butyrate chain.

The main advantage of the direct alkylation route is the  
30 relatively high yields that can be obtained. However, there are several drawbacks. Direct methylation of unprotected lovastatin (U.S. patent 4,582,915) results in a rather impure simvastatin, containing a relatively high amount of unconverted lovastatin and many byproducts. Therefore, protection of the pyranone ring  
35 is required. A reduction of the byproducts was achieved by protecting the pyranone ring of lovastatin prior to the

alkylation with t-butyl dimethyl silyl chloride (European patent EP299656). However this is a very expensive protecting group. A less expensive protecting group is boronic acid as disclosed in international patent application WO 95/13283.

5 Nevertheless, this route still suffers from the fact that it is difficult to obtain a complete conversion of the 2-methyl butyrate side chain into the 2,2-dimethyl butyrate side chain. Therefore, an additional purification is necessary. For example base hydrolysis of the remaining lovastatin to triol acid with  
10 NaOH or LiOH, in which also part of the simvastatin is hydrolysed, followed by crystallization. Alternatively selective enzymatic hydrolysis of lovastatin (U.S. patent 5,223,415) may be applied. However, these extra purification steps will reduce the yield, and make the process less efficient.

15 The second route, wherein the 2-methyl butyrate side chain is completely removed and another side chain is added, offers intrinsically a better quality product, as the separation of the hydrolyzed product and the esterified product is much easier to  
20 achieve compared to the unreacted starting material and the methylated product.

In US patent 4,293,496 the removal of the 2-methyl butyrate side chain is achieved by base hydrolysis of lovastatin with an alkali metal hydroxide, preferably LiOH. This reaction requires  
25 long processing times (50-72 hours while refluxing) or rather stringent conditions (120°C-180°C) if shorter process times are used.

In US patent 4,444,784 the introduction of a new side chain to the hydrolyzed lovastatin is disclosed. It involves several  
30 separate steps: relactonization of the mevinic acid, protection of the hydroxy group in the pyranone ring by reaction with t-butyl dimethyl silyl chloride, esterification with 2,2-dimethyl butyric acid and deprotection of the hydroxy group of the pyranone ring. The main disadvantages of this process route are  
35 the low yields, and the use of an expensive protecting group, viz. t-butyl dimethyl silyl.

- 3 -

A much less expensive protecting group is disclosed in US patent 5,159,104. Instead of the t-butyl dimethyl silyl protection of the OH-group in the pyranone ring, the OH-group was esterified with an acetic anhydride or an acylhalide. However, this process  
5 still suffers from a poor yield.

The present invention provides a new, rather inexpensive, crystalline intermediate which can be used in both synthesis routes. In addition a novel, quick and less expensive process  
10 for the quantitative removal of the 2-methyl butyryl side chain and addition of another side chain, is disclosed, including novel, crystalline intermediates for the preparation of semi synthetic lovastatin and compactin intermediates. Besides that, a much higher yield for the removal of the side chain of about  
15 95% was obtained compared to the yield of about 65% obtained in a comparable process as described by Askin et al in J. Org. Chem. 1991 vol 56, pages 4929-4932. Furthermore, by the application of the process of the present invention for the synthesis of semisynthetic statins, as for instance simvastatin,  
20 the use of the carcinogenic methyliodide is avoided, which is required in the direct methylation route.

The process of the present invention comprises a surprisingly selective removal of the 8' (R<sub>3</sub>')-side chain, for instance the 2-methyl butyryl side chain in lovastatin, to triol acid  
25 intermediate and another alcohol, by reduction with a reducing agent such as LiAlH<sub>4</sub> or a Grignard reagent, or to a triol acid intermediate and an amide by reaction with an amine. During this reaction the starting material is quantitatively converted into the triol acid intermediate, which offers excellent  
30 possibilities for the introduction of various side chains.

#### DESCRIPTION OF THE FIGURES

Figure 1: Scheme of the process to prepare semi synthetic statins, depicted as formula I, from a statin, preferably a  
35 naturally occurring one, by removal of the 8'-side (R<sub>3</sub>') chain including the novel intermediates of formula II and IV, depicted as II', III, IV and II. The figure displays only one of the

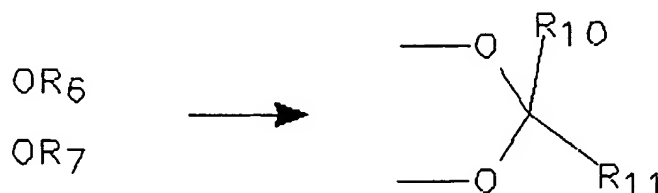
possible stereoisomers as example, but should not be regarded as limited thereto.

Figure 2: Scheme of the process to prepare semi synthetic statins, depicted as formula I, by applying direct  $\alpha$ -methylation on the ester moiety of a compound of formula II'.

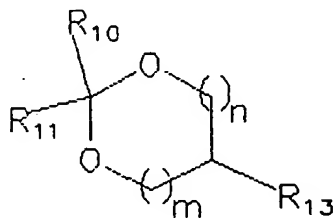
#### SUMMARY OF THE INVENTION

10 The present invention provides a novel process for the production of semi synthetic statins, defined as formula I, depicted in figure I from a statin defined as formula I, depicted as formula I' in figure I, wherein  $R_1$  and  $R_2$  are independently selected from the group consisting essentially of  
15 a hydrogen atom, a hydroxyl,  $C_{1-10}$ alkyl,  $C_{6-14}$ aryl and  $C_{6-14}$ aryl- $C_{1-3}$ alkyl, preferably methyl, and wherein  $R_3$  and  $R_3'$  are independently selected from the group comprising  $R_3$ -CO- and hydrogen, and wherein  $R_3$  is selected from the group comprising:  
20 (1)  $C_{1-15}$  straight or branched alkyl,  
(2)  $C_{3-15}$ cycloalkyl,  
(3)  $C_{2-15}$ alkenyl, straight or branched  
(4)  $C_{2-15}$ alkynyl, straight or branched,  
(5) phenyl,  
(6) phenyl $C_{1-6}$ alkyl-,  
25 all optionally substituted with one or more of the substituents independently selected from the group comprising halogen,  $C_{1-6}$ alkyl,  $C_{1-6}$ alkoxy,  $C_{6-14}$ aryl as for instance phenyl or aromatic heterocycle,  
preferably  $R_3$  is 2,2-dimethylbutyryl and  $R_3'$  is 2-methylbutyryl,  
30 and wherein the dotted lines at x, y and z represent possible double bonds, when any are present, being either x and z in combination or x, y or z alone or none, with the proviso that the double bonds of a compound as defined in formula I are the same as the double bonds of a compound as defined in formula I',  
35 by ring opening of the lactone by forming an amide bond by reaction with ammonia or with primary amines, preferably n-butylamine and cyclohexylamine or secondary amines, preferably

piperidine and pyrrolidine, and subsequently optional protection of the hydroxyl groups, for instance by formation of a dioxane moiety at  $R_6$  and  $R_7$ ,



5 by reaction with a ketone, defined as  $R_{10}-CO-R_{11}$ , or an aldehyde defined as  $R_{10}-CO-H$ , or an acetal defined as



or  $H(CH_2)_nCHR_{13}(CH_2)_m-OR_{10}CR_{11}O(CH_2)_m\cdot CHR_{13}'(CH_2)_n\cdot H$

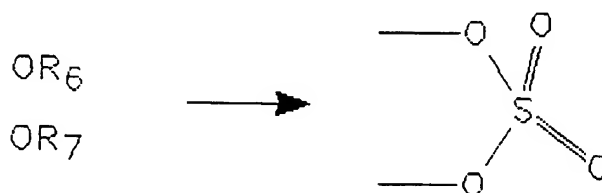
wherein  $R_{10}$  and  $R_{11}$  are each independently selected from the  
 10 groups comprising hydrogen, halogen,  $C_{1-6}$ alkyl-,  $C_{1-6}$ alkoxy,  $C_{6-14}$ aryl as for instance phenyl or aromatic heterocycle and  $m$ ,  $n$ ,  $m'$  and  $n'$  are each independently 0 - 10,  
 wherein  $R_{10}$  and  $R_{11}$  are independently selected of the group comprising:

- 15 (1)  $C_{1-15}$ alkyl, straight or branched,
- (2)  $C_{3-15}$ cycloalkyl,
- (3)  $C_{2-15}$ alkenyl, straight or branched,
- (4)  $C_{2-15}$ alkynyl, straight or branched,
- (5) phenyl,
- 20 (6) phenyl $C_{1-6}$ alkyl-,

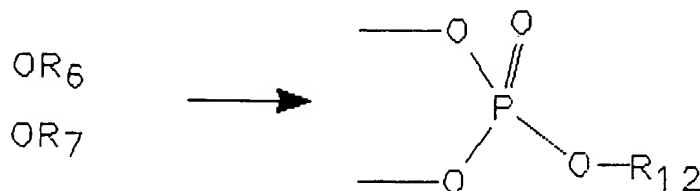
all optionally substituted with one or more of the substituents independently selected from the group comprising halogen,  $C_{1-6}$ alkyl,  $C_{1-6}$ alkoxy,  $C_{6-14}$ aryl as for instance phenyl or an aromatic heterocycle,

- 25 (7) hydrogen, with the proviso that  $R_{10}$  is not hydrogen,

- (8)  $R_{10}$  and  $R_{11}$  are forming an optionally substituted 5, 6, 7 or 8 membered cyclic moiety, in which the substituents comprise halogen and a  $C_{1-6}$ alkyl in any combination,
- 5 preferably  $R_{10}$  and  $R_{11}$  are methyl,
- in the presence of catalytic agents, preferably an acid such as para-toluene sulphonic acid (p-TsOH) or sulfuric acid,
- or by reaction with silylating agents, preferably t-butyl dimethyl silyl chloride,
- 10 or by formation of protective groups, such as for instance:
- (1) cyclic sulfate,



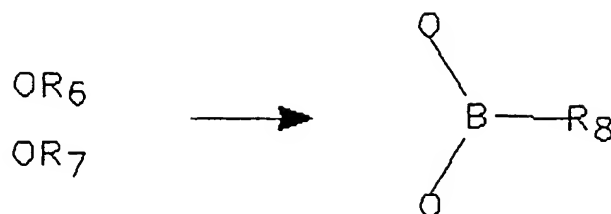
- (2) cyclic phosphate,



- 15 in which  $R_{12}$  is selected from a group comprising:
- (1)  $C_{1-15}$  straight or branched alkyl,
  - (2)  $C_{3-15}$ cycloalkyl,
  - (3) phenyl,
  - (4) phenyl- $C_{1-6}$ alkyl,
  - 20 (5) hydrogen,
  - (6) primary amines, preferably n-butylamine and cyclohexylamine or secondary amines, preferably piperidine and pyrrolidine,
- (3) borylidene



- 7 -



- in which  $\text{R}_8$  is a phenyl optionally substituted by one to five substituents, halogen or  $\text{C}_{1-6}$ alkyl in any combination, preferably phenyl or para fluoro phenyl,
- followed by removal of the ester  $\text{R}_3'$  moiety by reduction with
- 5 suitable reducing agents, such as lithiumaluminumhydride, methylmagnesiumchloride or n-butyllithium,
- or by reaction with a primary amine  $\text{R}_4\text{NH}_2$  wherein  $\text{R}_4$  is selected from the group comprising
- (1)  $\text{C}_{1-15}$  straight or branched alkyl,
  - 10 (2)  $\text{C}_{3-15}$ cycloalkyl,
  - (3)  $\text{C}_{2-15}$ alkenyl, straight or branched,
  - (4)  $\text{C}_{2-15}$ alkynyl, straight or branched,
  - (5) phenyl,
  - (6) phenyl $\text{C}_{1-6}$ alkyl-,
  - 15 all optionally substituted with one or more of the substituents independently selected from the group comprising halogen,  $\text{C}_{1-6}$ alkyl,  $\text{C}_{1-6}$ alkoxy, aryl as for instance phenyl or aromatic heterocycle,
  - (7) hydrogen,
  - 20 followed by acylation with the acid chloride or the free acid of the corresponding  $\text{R}_3$  group or the optionally symmetric anhydride, with the proviso that in case  $\text{R}_6$  and  $\text{R}_7$  are hydrogen, the corresponding hydroxyl groups are protected as described above before this acylation reaction is carried out,
  - 25 followed by the removal of the protective group and of the amide by hydrolysis, into a compound of formula V, depicted in figure I, wherein M forms any pharmaceutically acceptable salt, acid or ester thereof,
  - optionally followed by lactonization by heating, and finally by
  - 30 crystallization.

The present invention also provides a number of novel intermediates of formula II, depicted as II', III and II in figure I, and of formula IV in figure I, wherein  $R_1$ ,  $R_2$ ,  $R_3$  and  $R_3'$  and the double bonds x, z and y are defined as above in formula I, and  $R_4$  and  $R_5$  are independently selected from the groups as defined for  $R_4$  in  $R_4NH_2$  above and  $R_4$  and  $R_5$  may form with the nitrogen to which they are attached, a 5, 6 or 7 membered heterocycle moiety such as a pyrrolidine, piperidine or a homopiperidine,

and wherein  $R_6$  and  $R_7$  are independently selected from the group which form:

- (1) a dioxane moiety,  
with  $R_{10}$  and  $R_{11}$  defined as above,
- (2) a cyclic sulfate,
- (3) a cyclic phosphate, with  $R_{12}$  defined as above, and with the proviso that when  $R_3$  is hydrogen,  $R_6$  and  $R_7$  may also form a borylidene group, wherein  $R_8$  is defined as above and  $R_6$  and  $R_7$  may be both hydrogen.

The processes disclosed for the preparation of said intermediates above, form a substantial part of the invention. The present invention also provides the preparation of a compound of formula I, as described above, with the proviso that  $R_3$  comprises an alkyl group on the  $\alpha$ -position, from a compound of formula I', as described above, with the proviso that  $R_3'$  comprises a hydrogen on the  $\alpha$ -position, followed by ring opening of the lactone by forming an amide bond by reaction with ammonia or with primary amines, preferably n-butylamine and cyclohexylamine or secondary amines, preferably piperidine and pyrrolidine, and subsequently optional protection of the hydroxyl groups, for instance by formation of a dioxane moiety at  $R_6$  and  $R_7$ , with  $R_{10}$  and  $R_{11}$  defined as above, followed by direct  $\alpha$ -alkylation of the  $R_3'$  moiety of formula II, depicted in figure I as formula II', forming a compound of formula II, defined as above, with the proviso that  $R_3$  comprises an alkyl group on the  $\alpha$ -position, exemplified in figure II, by

reaction with an alkyl halogenide, for instance methyl iodide (MeI).

This present invention provides the use of the processes as described above for preparing a compound of formula I, as described above, from a compound of formula I', as described above, containing upto about 30% of impurities, as for instance oxidized compounds or di- or tetra-hydro statins. Preferably simvastatin is produced in this way, starting from lovastatin contaminated with dihydrolovastatin and optionally oxidized compounds.

#### DETAILED DESCRIPTION OF THE INVENTION

The process of the invention comprises the following steps:

1) Conversion of a compound of formula I' defined as above into a compound of formula II' defined as above, by:

- a) ring opening of the lactone by formation of an amide bond with an excess of amine optionally mixed with an inert organic solvent as for instance toluene, cyclohexane, tetrahydrofuran, acetonitrile, preferably an amine with a boiling point higher than 60°C, at a temperature above about RT, preferably higher than 60°C, where after complete conversion the excess of amine is removed, for instance by evaporation, or by washing with dilute acid,
- b) optionally followed by protecting the hydroxy groups of the former lactone by reaction of the formed amide with a ketone or aldehyde or acetal, optionally mixed with an inert organic solvent as for instance toluene, cyclohexane, tetrahydrofuran, acetonitrile or ethylacetate, between 5°C and 50°C, preferably around room temperature in the presence of a catalytic agent as for instance p-toluene sulphonic acid (p-TsOH) or sulfuric acid, or by reaction of the formed amide with sulfonyl chloride in dichloromethane at temperatures between -20°C and 20°C, preferably between -5°C and 5°C, followed by oxidation to form the sulfate, for instance with sodiumperiodate in a suitable solvent, for instance a mixture of water and

acetonitrile in the presence of a catalyst, for instance Ruthenium chloride,

or by reaction of the formed amide with phosphonyl chloride in an inert organic solvent as for instance toluene at  
5 temperatures between 5°C and 50°C, preferably between 15°C and 25°C, followed by reaction with an alcohol, or an amine or water,

or the formation of borylidene moiety as described in international patent application WO 95/13283 mentioned  
10 above,

or the reaction with t-butyl dimethylsilyl chloride as described in US patent US 4,444,784 mentioned above.

2) Conversion of the compound of formula II' formed in step 1 to a compound of formula III as defined above, by removal of the  
15 R<sub>3</sub>' moiety with a suitable reagent, as for instance:

a) reduction with lithiumaluminiumhydride, aluminiumhydride or diisobutylaluminiumhydride in an inert solvent as for instance toluene or tetrahydrofuran (THF) at temperatures between 0°C and 30°C, preferably between 5°C and 10°C,  
20 whereafter the reaction mixture is neutralized with for instance water or potassium hydroxide or sodium hydroxide or ethylacetate to neutralize the excess of lithiumaluminiumhydride,

b) reduction with an organic-metallic compound such as a Grignard reagent in an inert solvent as for instance THF  
25 at temperatures between -10°C and 20°C, preferably between -5°C and 10°C, or such as an alkylolithium compound as for instance n-butyllithium in an inert solvent as for instance THF at temperatures between -70°C and -20°C.

c) reaction with a primary amine or ammonia, preferably at a molar ratio equal to or greater than 1:1 with respect to the compound of formula II', optionally in the presence of water or an organic solvent, at a temperature between about 100°C and 250°C, preferably between about 130°C and 200°C,  
30 optionally at superatmospheric pressure, dependent on the boiling points of the reactants and solvents applied.  
35

3) Conversion of the compound of formula II as defined above, with the proviso that  $R_3$  is hydrogen (depicted as formula III in Figure I) formed in step 2 to a compound of formula IV in case  $R_5$  is hydrogen, or a compound of formula II in case  $R_5$  is not hydrogen, defined as above by acylation with

- a) the corresponding acid chloride in the presence of a base, such as triethylamine as a scavenger for HCl or with
  - b) the corresponding free acid optionally in the presence of a carbodiimide such as 1,3 dicyclohexylcarbodiimide or
  - 10 c) the corresponding optionally symmetric anhydride,
- in an organic solvent in the presence of a catalyst as for instance 4-dimethylaminopyridine (DMAP) at a temperature between 20°C and 110°C, preferably between 80°C and 110°C.

4) Conversion of a compound of formula II, formed in step 3, to  
15 a compound of formula V defined as above, by:

- a) removal of the protecting groups at  $R_6$  and  $R_7$  as for instance by hydrolysis in a mixture of water and an organic solvent, such as THF in the presence of a catalyst, as for instance hydrogen chloride or sulphuric acid or p-TsOH at  
20 temperatures between 20°C and 100°C, preferably between 30°C and 70°C,
- b) followed by the removal of the amide by hydrolysis as for instance in a mixture of a solution of sodium hydroxide or potassium hydroxide in water and an organic solvent as  
25 for instance methanol, ethanol, toluene or tetrahydrofuran,
- c) optionally followed by reacting with an agent to form a compound of formula V, preferably with a base corresponding to a pharmaceutically acceptable salt, in an organic solvent as for instance methanol, toluene or  
30 ethylacetate to form the corresponding salt, for instance the ammonium salt.

5) Conversion of the compound of formula V, formed in step 4, into a compound of formula I, defined as above, by lactonization of the compound V in an inert solvent, as for instance toluene,  
35 ethyl acetate or cyclohexane at temperatures between 60°C and 110°C, preferably between 80°C and 100°C. Finally the formed

compound of formula I is isolated by crystallization methods known in the art.

It should be noted that using an amine for the removal of the  $R_3'$ -moiety as described in reaction step 2c of the process of the invention offers the possibility to combine the amide formation of reaction step 1a with 2c, whereby a compound of formula I, depicted as I' in figure 1 is directly converted into a compound of formula III, with  $R_6$  and  $R_7$  are each hydrogen.

It should further be noted that the process and compound provided by the present invention are not limited to the stereo isomers depicted in figure 1.

By an aryl group is meant an aromatic hydrocarbon group as for instance phenyl, naphthyl, anthryl or an aromatic heterocycle comprising for instance a nitrogen, a sulfur or oxygen atom.

By a corresponding amine is meant an amine, defined as  $R_4R_5NH$ , with  $R_4$  and  $R_5$  defined as above, reacting with a compound of formula I', defined as above, resulting in a compound of formula II', defined as above, wherein  $R_6$  and  $R_7$  are hydrogen and an  $R_4R_5NCO$  amide bond is formed, wherein  $R_4$  and  $R_5$  are the same as in the amine used.

By a corresponding acylation agent is meant a compound of formula  $R_3P$ , with P is OH or Cl or an anhydride  $R_3O:CO-O-R_{14}$ , with  $R_3$  is defined as above with the proviso that  $R_3$  is not hydrogen and  $R_{14}$  is defined as  $R_3$ , optionally  $R_{14}$  is the same as  $R_3$  resulting in a symmetric anhydride, which upon reaction with a compound of formula III, defined as above, results in a compound of formula IV, defined as above, or a compound of formula II, defined as above, wherein  $R_3$  is the same as in the acylation agent used.

In all processes of the present invention the possible double bonds x, y and z of the starting compounds are the same as those in the endproducts. Furthermore, also all other parameters as R groups remain the same for the endproduct compared to the starting material, unless otherwise indicated.

Surprisingly it was found that in the process for preparing pure simvastatin from lovastatin, impure lovastatin may be used,

- 13 -

which may contain upto about 30% of impurities, such as dihydrolovastatin or oxidized lovastatin.

Examples**Experimental**

The HPLC-analyses were carried out according to A. Houck et al, Talanta Vol 40 (4), 491-494 (1993):

- 5 Liquid Chromatographic determination of the known low level impurities in lovastatin bulk drug: an application of high-low chromatography

**HPLC**

- 10 -Alliance Waters pump/injector  
-M996 diode array Waters  
-Millennium data system Waters

-column: Prodigy 5 C8 250x4.6 mm (phenomenex)

15

**Conditions:**

injection volume: 10 $\mu$ l

gradient flow profile (linear)

A = acetonitrile

20 B = 0.1% H<sub>3</sub>PO<sub>4</sub>

TIME	FLOW	%A	%B
min	ml/min		
0	1.5	60	40
25 1	1.5	60	40
5	1.5	80	20
8	1.5	90	10
16	1.5	90	10
20	1.5	60	40

30

column temperature 30°C

Detection at 200 nm and 237 nm.

The samples were mixed in acetonitrile with a concentration of 1.5 mg/ml.

35

Retention times:

dihydro simvastatin 8.10 min (200 nm)



- 15 -

	simvastatin acid	5.77 min (237 nm)
	lovastatin	6.34
	simvastatin	7.11
	dehydro simvastatin	8.90
5	dimer simvastatin	15.36

#### Example 1:

##### Formation of lovastatin piperidinamide:

A mixture of 1 g (2.5 mmol) of lovastatin, 10 ml (0.1 mol) of  
10 piperidine, 100 mg (0.82 mmol) of N,N-dimethylaminopyridine and  
30 ml of toluene was refluxed for 36 hours. The mixture was  
cooled to RT and washed with 2x30 ml of 2 N HCl and 2x20 ml of  
water. The organic layer was dried with sodium sulfate, filtered  
and evaporated. The residue was stirred with hexane and the  
15 resulting precipitate was filtered to give 0.87 g of lovastatin  
piperidinamide as a white solid.

#### Example 2:

##### Reaction of lovastatin butylamide with thionylchloride:

20 0.76 G (7.5 mmol) of triethylamine was added to a solution of  
1.2 g (2.5 mmol) of lovastatin butylamide in 20 ml of toluene.  
Surprisingly 0.45 g (3.7 mmol) of thionylchloride was added  
dropwise. After 1 hour at room temperature the reaction mixture  
was washed with water, dried (sodium sulphate), filtered and  
25 evaporated to give a brown oil.

#### Example 3

##### Reaction of lovastatin butylamide with phosphorylchloride:

0.76 G (7.5 mmol) of triethylamine was added to a solution of  
30 1.2 g (2.5 mmol) of lovastatin butylamide in 20 ml toluene. Next  
0.58 g (3.8 mmol) of phosphorylchloride was added dropwise.  
After 1h at room temperature the reaction mixture was filtered,  
dried (sodium sulphate), filtered and evaporated to give a brown  
oil.

35

Example 4:Process for preparing simvastatin by direct methylation.A. Formation of the acetonide of lovastatin butylamide, exemplified as formula II' in figure II:

A mixture of 40 g (98 mmol) of lovastatin and 60 ml of n-butylamine was refluxed for 1 hour, evaporated and coevaporated twice with 100 ml of toluene. The resulting crude amide was dissolved in 500 ml of acetone and 3 g of p-TsOH was added. The clear solution was stirred at room temperature (RT) for two hours at which time a solid was formed. The mixture was cooled to -10°C for three hours and the solid was collected and dried to afford 45 g (88%) of the amide/acetonide as a white solid. From the mother-liquor another 5 g was obtained, by partially evaporation of the solvent.

B. Alkylation of amide/acetonide intermediate formed in step A:

The amide/acetonide (19.5 g, 37.6 mmol) in 280 ml THF/cyclohexane (4/1) was cooled to -40°C and 113 ml 1M lithium-pyrrolide (prepared from pyrrolidine and n-butyllithium at -15°C) was added maintaining the temperature at <-30°C. The solution was stirred at -35°C for two hours and 5 ml MeI was added in one portion. The solution was stirred at -30°C for one hour and the temperature was allowed to rise to -10°C. 300 ml of 1N HCl was added and the resulting mixture was refluxed for one hour. Ethyl acetate (300 ml) was added and the organic layer was washed with 100 ml of 3N HCl and evaporated.

300 ml of methanol and 125 ml of 2N NaOH were added to the residue. The mixture was refluxed for 12 hours and most of the methanol was evaporated. 120 ml of water and 300 ml of ethyl acetate were added and the pH was adjusted to 5 with 3N HCl. To the organic layer were added 60 ml of methanol and 25 ml of NH<sub>4</sub>OH/methanol (1/3). The resulting mixture was stirred for one hour at room temperature and then cooled to 10°C. The solid was collected and dried. The yield was 13.5 g (80%) of simvastatin ammonium salt.

Example 5:Process for the preparation of simvastatin from lovastatin by reduction of the R<sub>1</sub> ester moiety.5 A. Formation of the acetonide of lovastatin butylamide:

A mixture of lovastatin (40.5 g, 100 mmol) and 75 ml of n-butylamine was heated at reflux for 1 hour. The excess of amine was evaporated and coevaporated with 100 ml of toluene. To the crude amide was added 400 ml of acetone and 5 g of p-TsOH. The  
10 mixture was stirred at RT for 1 hour and then cooled in ice/water for 2 hours. The resulting solid was collected by filtration and dried. From the mother-liquor a second batch was obtained. Total yield 49 g (94-95%).

15 B1. Reduction of the intermediate formed in step A with lithiumaluminiumhydride:

The compound as formed in step A (45 g, 87 mmol) was dissolved in 200 ml of THF and added dropwise to a suspension of 7 g (2,1 equivalents) of lithiumaluminiumhydride (LiAlH<sub>4</sub>) in 100 ml of  
20 THF at 10-15°C in ca. 20 minutes. The mixture was stirred for 30 minutes. The reaction mixture was treated with a solution of 20% KOH (exothermic). The resulting salts were removed by filtration and washed with 200 ml of THF. The combined filtrates were evaporated to afford 35.5 g of a syrup.

25

B2. Reduction of the intermediate formed in step A with methylmagnesiumchloride (Grignard):

A solution of 2 g (3.9 mmol) of the compound as formed in step A, in 20 ml of THF was cooled to 0°C. A solution of 12 ml of 3M  
30 methylmagnesiumchloride was added dropwise in 20 minutes. After 18 hours at RT the lovastatin n-butylamide acetonide was converted completely.

35 B3. Reduction of the intermediate formed in step A with n-butyllithium:

A solution of the compound as formed in step A (1 g, 1.9 mmol) in 25 ml THF was cooled to -50°C. A solution of 2.5 M n-

butyllithium (2.74 ml) was added dropwise over a period of 10 minutes. After 18 hours stirring at RT the alcohol intermediate was formed.

5 C. Acylation of the intermediate formed in step B and conversion to ammonium salt of simvastatin:

3 G of 4-dimethylaminopyridine in 300 ml of pyridine was added to a solution of 25 g (57 mmol) of the intermediate formed in step B and the mixture was heated to 50-55°C, preferably 50°C.  
10 2,2-Dimethylbutyric acid chloride (50 ml) was added in one portion and the resulting mixture was stirred for 40 hours (HPLC-analysis showed complete conversion). To the reaction mixture 400 ml of water and 400 ml of ethylacetate (EtOAc) was added. The organic layer was subsequently washed twice with 10%  
15 NaHCO<sub>3</sub> (400 ml), with water (400 ml) and with a solution of 10% HCl (400 ml). The organic layer was evaporated and dissolved in 200 ml of THF, 200 ml water was added, followed by 10 g of p-TsOH. The mixture was refluxed for 2 hours. EtOAc (400 ml) was added, followed by 300 ml water. The organic layer was washed  
20 twice with 10% NaHCO<sub>3</sub> (400 ml) and evaporated. The residue was dissolved in 300 ml of MeOH and 170 ml of 2N NaOH was added. The resulting mixture was refluxed for 3 hours and cooled to RT. Most of the MeOH was evaporated and 120 ml of water was added. The pH was adjusted to pH=7 with 2N HCl and 300 ml of EtOAc was  
25 added. The pH was further adjusted to pH=4 and the layers were separated. To the organic layer was added 100 ml of EtOH, followed by 40 ml of NH<sub>4</sub>OH/MeOH (1/3). The mixture was stirred at -10°C for 2 hours and the solid collected and washed with EtOAc and EtOH (cold). Yield 16 g (62%), HPLC-analysis gave  
30 98,9% of the ammonium salt of simvastatin.

D. Conversion of the simvastatin ammonium salt to simvastatin:

A suspension of 9 g of the ammonium salt of simvastatin as formed in step C was heated in 250 ml of toluene at 100°C for  
35 6 hours. The mixture was refluxed for an additional 30 minutes, filtered and evaporated. To the residue 100 ml of cyclohexane was added and the solution was evaporated again. The crude

- 19 -

simvastatin was recrystallised from ca. 150 ml of cyclohexane to afford simvastatin as a white solid. Yield 85%, HPLC-analysis gave 98,4% of simvastatin.

5

Example 6:Process for the preparation of simvastatin from lovastatin by reduction of the R<sub>1</sub> ester moiety.**A: Preparation of the acetonide of lovastatin butyl amide.**

A mixture of 950 g of lovastatin (2.4 mol), 8 l of toluene and  
10 500 ml of n-butylamine (5 mol) is heated up to 85°C under nitrogen. The solution is kept at 85°C - 95°C during 2 hours, and is subsequently cooled to room temperature.

Then 5 l of 4 N sulfuric acid is added and the mixture is stirred during 5 minutes. The lower layer is removed, and 1.5 l  
15 (12 mol) of 2,2-dimethoxy propane are added to the upper layer. The solution is stirred during 30 minutes at room temperature, and thereafter the mixture is concentrated to 5.4 kg by evaporation at 55-60°C under vacuum.

**20 B: Reduction of the intermediate formed in step A with lithium aluminium hydride**

5.8 l (5.5 kg, corresponding to 2.4 mol of the intermediate obtained in step A) of the concentrate obtained in step A is mixed with 2 l of toluene. The mixture is cooled to 0°C under  
25 a nitrogen atmosphere. 6 L of a 1 N solution of Lithium aluminium hydride in toluene (6 mol LiAlH<sub>4</sub>) is added over a period of 75 minutes, during which the temperature is kept below 8°C. The resulting mixture is stirred for 3 hours at 5-10°C, then 5.3 l of water over a period of 100 minutes, keeping the  
30 temperature below 10-15°C.

Subsequently, 5 l of 4 N sulfuric acid is added to the suspension and the mixture is stirred during 15 minutes. Hereafter, the layers are allowed to settle. The milky lower layer is removed, and the upper layer is washed with 4.5 l of  
35 water and with 6 l of an aqueous 1 N sodium hydroxide solution. 6 L of the upper layer is removed by evaporation at 50-60°C under vacuum (150-300 mm Hg).

**C: Acylation of the intermediate obtained in step B with 2.2-dimethyl butyryl chloride**

To the solution of the alcohol intermediate in toluene obtained in step B, containing 2.4 mol of intermediate, 250 ml of toluene  
5 containing 35 g (0.29 mol) of 4-(N,N-dimethyl amino)pyridine, 1.6 l of triethylamine (11.4 mol) and 1.5 kg (11 mol) of 2.2-dimethyl butyryl chloride are added. The resulting solution is heated to 105-110°C, and stirred at this temperature during 10 hours under nitrogen.

10 Hereafter, the resulting suspension is cooled to room temperature, and 3 l of 4 N sulfuric acid is added. The mixture is stirred for 5 minutes, and then the layers are allowed to separate. Subsequently the lower layer is removed, and the upper layer is washed with 2 l of 4 N sulfuric acid.

15

**D: Preparation of simvastatin ammonium salt**

The reaction mixture obtained in Step C (circa 11 l) is mixed with 4.5 l of 4 N sulfuric acid. The mixture is subsequently heated at 70-75°C during 3 hours, while nitrogen is led through  
20 the mixture. Then the mixture is allowed to cool to room temperature, and the lower layer is removed. The upper layer is cooled to 5°C and washed with 2.5 l of 2 N sodium hydroxide. After removal of the lower layer, 6 l of 2 N sulfuric acid is added and stirred during 3 hours at room temperature, and then  
25 at 45-55°C during 3 hours. The suspension is cooled to 5-10°C, whereafter 2.75 l of 4 N sulfuric acid is added while the temperature is kept below 10°C. Then the lower layer is removed, and 1 l of a concentrated  $\text{NH}_4\text{OH}$  solution is added. Subsequently, the mixture is concentrated at 50-60°C under vacuum in order to  
30 remove toluene and water. 3 l of ethyl acetate is added to the residue, and the mixture is stirred at 50°C during 30 minutes to obtain a homogeneous suspension. The suspension is cooled to room temperature and filtered under vacuum. The filter cake is subsequently washed with 1 l of ethyl acetate and subsequently  
35 it is suspended in 4 l of ethyl acetate, heated at 50°C for 90 minutes, the warm suspension is filtrated and the filter cake

- 21 -

is washed in ethyl acetate, yielding 891 g of crystals of simvastatin ammonium salt.

**E: Preparation of simvastatin**

5 570 g of the ammonium salt crystals as obtained in step D are suspended in 13 l of toluene. Subsequently 2 l of water is added, and the pH is adjusted to 3 by addition of 4 N sulfuric acid. The mixture is stirred during 30 minutes, whereafter the lower layer is removed. The upper layer is subsequently washed  
10 with 2 l of water, and concentrated by evaporation of 4 l of toluene at 50-60°C under vacuum.

The remaining solution is heated at 85-92°C under nitrogen during 2.5 hours. Then, the solution is cooled to 15°C, 3 l of water is added and the pH is adjusted to pH 8-8.5 by addition  
15 of a solution of 1 N NaOH. The lower layer is removed and 3 l of water is added to the upper layer followed by adjustment of the pH to 6 by adding 6N sulfuric acid.

The lower layer is removed, and the upper layer is concentrated to 1 l by evaporation at 50-60°C under vacuum.

20 Subsequently 350 ml of n-hexane is added over a period of 1 hour at 50-60°C. Subsequently the mixture is stirred at 50-60°C during 30 minutes and then slowly cooled to 15°C over a period of 2 hours. The crystals are filtered and washed with 350 ml of a mixture of n-hexane/toluene (5/1), yielding 440 g of  
25 simvastatin.

**Example 7:**

**Process for the preparation of simvastatin ammonium salt by reduction of the R<sub>1</sub> ester moiety of lovastatin.**

30

**A. Formation of lovastatin cyclohexanamide:**

A mixture of 5 g (0.012 mol) of lovastatin, 6 ml (0.052 mol) of cyclohexylamine and 50 ml of toluene was refluxed for 6 hours. The reaction mixture was cooled to RT and 20 ml of ethylacetate  
35 was added. The mixture was washed with 2N HCl (2 x 30ml) and water (2 x 20ml). The organic layer was dried with sodium sulfate, filtered and evaporated to a volume of 15 ml. 50 ml of

hexane was added and the precipitate was filtered to give 5.5 g of lovastatin cyclohexanamide as a white powder.

B. Formation of lovastatin cyclohexanamide acetonide:

5 To a solution of 5 g (10 mmol) of lovastatin cyclohexanamide in 25 ml of acetone was added 300 mg (1.6 mmol) of p-TsOH. After 18 hours stirring at RT the solution was poured into a mixture of 50 ml ethylacetate and 50 ml, 10% sodium bicarbonate solution. The ethylacetate layer was separated, washed with 30  
10 ml, 10% sodium bicarbonate solution, dried with sodium sulfate, filtered and evaporated. The residue was dissolved in toluene and which was subsequently evaporated to give 4.9 g of the acetonide of lovastatin cyclohexanamide.

15 C. Formation of simvastatin ammonium salt:

A suspension of 836 mg (22 mmol) of lithiumaluminiumhydride in 15 ml of THF was cooled to 0°C and a solution of 4.93 g (9.1 mmol) of the compound formed in step B, in 20 ml of THF was added dropwise over a period of 15 minutes. After 18 hours at  
20 RT the reaction mixture was cooled at 0°C and 1 ml of water and of a 10% potassium hydroxide solution were added subsequently. The mixture was filtered over Celite and the THF was evaporated to give the corresponding 4.3 g (9 mmol) of alcohol intermediate.

25

D. Formation of simvastatin ammonium salt:

A mixture of 4.3 g (9 mmol) of the alcohol intermediate, 40 ml of pyridine, 200 mg N,N-dimethylaminopyridine and 7.2 g, (54 mmol) of 2,2-dimethylbutyric acid chloride was stirred for 72  
30 hours at 65°C. The mixture was cooled, 100 ml of toluene was added and the mixture was washed with 2x50 ml of a 10% sodium bicarbonate solution and 30 ml of brine. The toluene layer was dried with sodium sulfate, filtered and evaporated. The residue was dissolved in 100 ml of toluene, which was subsequently  
35 evaporated.

The residue was dissolved in 20 ml of THF and 20 ml of water. Next 1 g of p-TsOH was added and the solution was refluxed for



- 23 -

5 hours. The solution was poured into a mixture of 70 ml of toluene and 50 ml of 10% sodium bicarbonate solution. The organic layer was separated and washed with 30 ml of 10% sodium bicarbonate solution. The organic layer was dried, filtered and  
5 evaporated to give 4,8 g residue.

The residue was dissolved in 70 ml of methanol and 40 ml of 2M NaOH. The reaction mixture was refluxed for 72 hours. The methanol was evaporated and the water layer was cooled to 0°C. The water layer was acidified to pH = 5 with a 2N HCl solution.  
10 Next 75 ml of ethylacetate was added and the organic layer was separated. To the ethylacetate was added 5 ml 25% of ammonia solution. The precipitate was filtered to give 1.1 g of the ammonium salt of simvastatin, with an overall yield of 27% from the acetonide of lovastatin cyclohexanamide.

15

#### Example 8:

#### Preparation of diacylated simvastatin butylamide:

##### A. Silylation of lovastatin butylamide

20 T-butyl dimethylsilyl lovastatinbutylamide was prepared by literature procedure (Askin D; Verhoeven, T.R.; Liu, T.M.-H.; Shinkai, I. *J.Org.Chem*, 1991, 56, 4929) and obtained with a yield of 68% (crude material), HPLC  $R_f$ : 12.87.

##### 25 B. Reduction of t-butyl dimethylsilyl lovastatin butylamide

A solution of t-butyl dimethylsilyl lovastatin butylamide (1,65 g, 2.34 mmol) in THF (30ml) was added to a 1M solution of  $\text{LiAlH}_4 \cdot 2\text{THF}$  in toluene (6ml, 2.5 eq,) at 0°C. The reaction mixture was stirred for 2h, after which moist sodium sulfate  
30 ( $\text{Na}_2\text{SO}_4 \cdot n\text{H}_2\text{O}$ ) was added until gas evolution ceased. Attempts to filter the slurry over a glass funnel (P2) with Celite layer failed. The reaction mixture was poured in dilute HCl (<1N). The water layer was extracted with diethylether. The organic layer was washed with brine, dried ( $\text{Na}_2\text{SO}_4$ ) and evaporated. Yield:  
35 1.07 g (89%).  
HPLC:  $R_f$ :9.27.

C. Acylation of t-butyl silyl protected lovastatin butylamide alcohol

To a solution of the alcohol intermediate obtained in step 8B (360 mg, 0.58 mmol) and triethylamine (0.32 ml) in toluene (10 ml), 2,2-dimethylbutyryl chloride was added. (0.31 g, 4 eq.). The reaction mixture was heated to reflux for 10h (standard procedure). HPLC analysis showed a mixture of compounds among which the desired diacylated product ( $R_f$ :15,81). Removal of the protecting groups according to the method described in Askin D; Verhoeven, T.R.; Liu, T.M.-H.; Shinkai, I. *J.Org.Chem*, 1991, 56, 4929) and obtained with a yield of 68% (crude material), HPLC  $R_f$ : 12.87.

Example 9:

15 Preparation of the diacetylbenzylidene derivative of lovastatin:

A) Formation of the benzylidene derivative of lovastatin butylamide

The lovastatin butylamide (4.77 g, 10 mmol) was dissolved in toluene (50 ml). Thereafter, benzaldehyde (10.6 g, 10 eq) and p-TsOH (500 mg) were added and stirred during 16 hours at room temperature. A saturated aqueous solution of  $\text{NaHCO}_3$  was added and the layers were separated. The toluene layer was washed with saturated  $\text{NaHCO}_3$  (aq), saturated  $\text{NaCl}$  (aq), dried ( $\text{Na}_2\text{SO}_4$ ) and evaporated. The residue was purified further by applying column chromatography ( $\text{SiO}_2$ /n-Hexane/ethylacetate, which yielded 2.6 g (46%) of the endproduct.

B) Reduction of the benzylidene derivative

The benzylidene derivative (2.6 g, 4.6 mmol) was dissolved in toluene (50 ml) and the solution was cooled to 0°C. Then a solution of 1M  $\text{LiAlH}_4 \cdot 2\text{THF}$  (11.5 ml) in toluene was added dropwise while the temperature was kept under 10°C. Then the solution was stirred for 2 hours at 0-5°C. Hereafter 30%  $\text{NaOH}$  (aq, 1.8 ml) was added and the mixture was stirred for 16 hours at room temperature. The mixture was filtered over Celite, washed with toluene (50 ml) and concentrated to about 50 ml.

- 25 -

C) Formation of the benzylidene derivative of simvastatin

Triethylamine (1.9 g, 4.1 eq), dimethylbutyric acid (2.5 g, 4 eq) and dimethylaminopyridine (50 mg) were added to the reaction mixture formed in step 9B and refluxed during 16 hours.

- 5 The mixture was then poured into water/ethylacetate and separated.

The organic layer was subsequently washed with water, followed by saturated sodium chloride, then dried with sodium sulfate and evaporated, yielding 3.3 g of crude product.

- 10 Further conversion of the product to simvastatin to be carried out according to the procedure described in Example 5C and 5D, second part.

Example 10:

- 15 Lovastatin reduction of the acetonide of lovastatin pyrrolidin amide:

- 40 Mg (1.1 mmol) of lithiumaluminiumhydride was added at 0°C to a solution of 1 g (1.94 mmol) of the acetonide of lovastatine pyrrolidin butylamide (prepared analogous to the method described in example 3 by reaction of lovastatin and pyrrolidin) in 20 ml THF. After 18 hours at room temperature the conversion was 50%.

Example 11Reduction of lovastatin butylamide:

- 25 To a suspension of LiAlH<sub>4</sub> (400 mg 10.5 mmol) in THF (50 ml) was added a solution of lovastatin butylamide (2.25 g, 5 mmol) in THF (25 ml) at 0°C. The mixture was stirred for 16 h at ambient temperature. Moist sodium sulfate (Na<sub>2</sub>SO<sub>4</sub>.n2H<sub>2</sub>O, Glauber salt analogue) was added until gas evolution ceased after which dry Na<sub>2</sub>SO<sub>4</sub> was added. The slurry was filtered over a glass filter and the filtrate was evaporated under reduced pressure to dryness to give a thick brown oil (1.03 g, 53%) HPLC of the crude material; R<sub>f</sub>; 2.93 (and 5.79, starting material).

Example 12:

Selective acylation reaction on the nitrogen of the lovastatin butylamide acetonide alcohol, whereafter the OH group can be acylated:

5 To a solution of lovastatin butylamide acetonide alcohol (2.1 g, 5 mmol) and triethylamine (0.8 ml, 5.5 mmol) in toluene (50 ml) was added 1.1 eq. benzoyl chloride (0.64 ml, 5.5 mmol) at 0°C. The reaction mixture was stirred for 16h at room temperature. A HPLC sample displayed major peaks at  $R_f$  6.16  
10 (starting material) and 9.13. After 21 h a peak at 9.67 was coming up. NMR analysis showed a small NH peak and 3 other peaks in the regio 6,5-5 ppm, indicating that the amide is acylated.

Example 13:Reaction of lovastatin with ammonia

15 A suspension of 0.25 g (0.6 mmol) lovastatin in 15 ml of methanol was cooled to 5°C on an ice/water bath. The methanol was saturated with ammonia (gas) and the mixture was heated for  
20 40 hours at 130°C in a sealed tube. The reaction mixture contained 43% of the corresponding deacylated product according to HPLC-analysis.

Example 14:Reaction of lovastatin with n-butylamine

25 A solution of 0.5 g (1.2 mmol) of lovastatin in 15 ml of n-butylamine was heated for 40 hours at 150°C in a sealed vessel. The reaction mixture contained 12.3% of the corresponding deacylated product according to HPLC analysis.  
30 The structure of the deacylated butylamide was confirmed by forming the corresponding acetonide by reaction with pTsOH and acetone and comparing the acetonide with another sample of acetonide made by the process described in the second part of example 5A.

35

Example 15:Reaction of lovastatin with n-heptylamine

- 27 -

A solution of 0.25 g (1.2 mmol) of lovastatin in 10 ml of heptylamine was refluxed for 70 hours. The resulting reaction mixture contained 17% of the corresponding deacylated product according to HPLC analysis.

5

Example 16:

All three deacylated compounds from Examples 13, 14 and 15 were converted into the corresponding acetonide (i.e. by ring closure) by addition of 400 ml of acetone and 5 g of p-TsOH. The mixture was stirred for 1 hour (at room temperature) and then cooled in ice water for 2 hours. The resulting solid was collected by suction and dried.

10

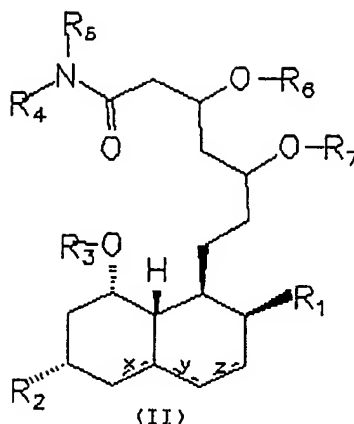
Example 17:

The three acetonide compounds resulting from Example 16 were then each individually converted to simvastatin using the acylation and ammonium salt conversion reactions as described in steps C and D of Example 5.

15  
20

CLAIMS

1. A compound of formula II,



wherein  $R_1$  and  $R_2$  are independently selected from the group consisting essentially of a hydrogen atom, a hydroxyl,  $C_{1-10}$ alkyl and  $C_{6-14}$ aryl and  $C_{6-14}$ aryl $C_{1-3}$ alkyl, and wherein  $R_3$  is  $R_3-C=O$  or hydrogen, and wherein each of  $R_6$ ,  $R_4$  and  $R_5$  are independently selected from the group comprising:

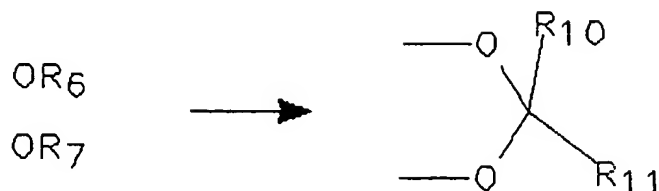
- (1)  $C_{1-15}$  alkyl, straight or branched,
- (2)  $C_{3-15}$ cycloalkyl,
- (3)  $C_{2-15}$ alkenyl, straight or branched,
- (4)  $C_{2-15}$ alkynyl, straight or branched,
- (5) phenyl
- (6) phenyl $C_{1-6}$ alkyl-

and  $R_5$  may also be each of the definitions mentioned under (1) to (6) substituted with one or more of the substituents independently selected from the group comprising halogen,  $C_{1-6}$ alkyl,  $C_{1-6}$ alkoxy and  $C_{6-14}$ aryl,

and  $R_4$  and  $R_5$  may also be hydrogen or form with the nitrogen to which they are attached, a 5, 6 or 7 membered heterocycle moiety such as a pyrrolidine, piperidine or a homopiperidine, and wherein  $R_6$  and  $R_7$  are also independently selected from the group which form:

- 29 -

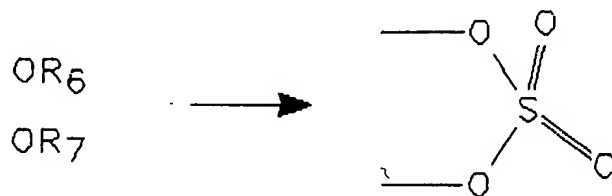
(1) a dioxane moiety,



wherein R<sub>10</sub> and R<sub>11</sub> are independently selected from the group comprising:

- 5 (1) C<sub>1-15</sub> alkyl, straight or branched,
  - (2) C<sub>3-15</sub>cycloalkyl,
  - (3) C<sub>2-15</sub>alkenyl, straight or branched,
  - (4) C<sub>2-15</sub>alkynyl, straight or branched,
  - (5) phenyl,
  - 10 (6) phenylC<sub>1-6</sub>alkyl-,
- all optionally substituted with one or more of the substituents independently selected from the group comprising halogen C<sub>1-6</sub>alkyl, C<sub>1-6</sub>alkoxy or C<sub>6-14</sub>aryl.
- 15 (7) hydrogen, with the proviso that R<sub>10</sub> is not hydrogen,
  - (8) R<sub>10</sub> and R<sub>11</sub> are forming an optionally substituted 5, 6, 7 or 8 membered cyclic moiety, in which one or more of the substituents are selected from the group comprising halogen and a lower alkyl in any combination,
  - 20

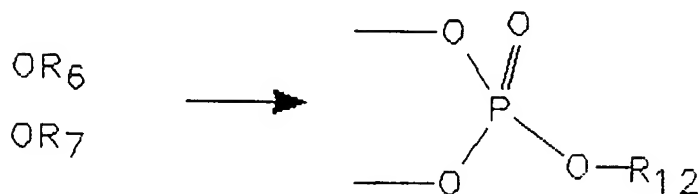
(2) a cyclic sulfate,



(3) or a cyclic phosphate,

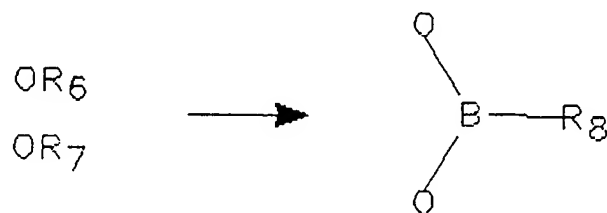
25

in which  $R_{12}$  is selected from the group comprising:



- 5 (1)  $C_{1-15}$  alkyl, straight or branched,  
 (2)  $C_{3-15}$  cycloalkyl,  
 (3) phenyl,  
 (4) phenyl $C_{1-6}$ alkyl-,  
 (5) hydrogen,  
 (6) primary amines, preferably n-butylamine  
 10 and cyclohexylamine or secondary amines,  
 and with the proviso that when  $R_3$  is hydrogen,  
 $R_6$  and  $R_7$  may also form a

- (1) borylidene group,

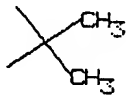


- 15 in which  $R_8$  is a phenyl optionally  
 substituted by one to five substituents,  
 halogen or lower alkyl in any combination,  
 preferably phenyl or para fluoro phenyl, or  
 (2)  $R_6$  and  $R_7$  are both hydrogen,  
 20 and wherein the dotted lines at x, y and z represent  
 possible double bonds, when any are present, being either  
 x and z in combination or x, y or z alone or none;  
 or a corresponding stereoisomer thereof.



- 31 -

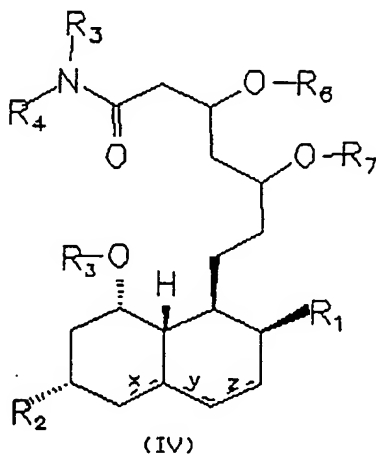
2. A compound according to claim 1, wherein independently  $R_1$  is methyl,  $R_2$  is methyl,  $R_3$  is 2-methylbutyrate,  $R_4$  is n-butyl,  $R_5$  is selected from the group consisting of hydrogen, 1-methylpropyl or 1,1-dimethylpropyl,  $R_6$  and  $R_7$  form together



5

$R_8$  is phenyl or parafluoro phenyl and x and z are double bonds.

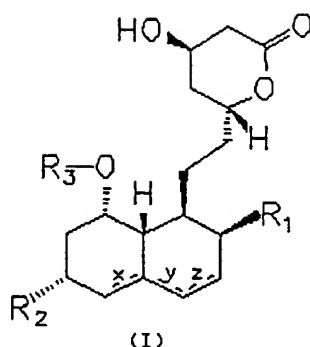
3. A compound of formula IV,



10 wherein  $R_1$ ,  $R_2$ ,  $R_3$ ,  $R_4$ ,  $R_6$  and  $R_7$  and x, y and z are defined as for a compound of formula II in Claim 1, or a corresponding stereoisomer thereof,  
with the proviso that  $R_3$  and  $R_4$  are not hydrogen, and  $R_6$  and  $R_7$  may also form a borylidene group, as defined in Claim 1.

15

4. A process for the preparation of a compound of formula II as defined in Claim 1 comprising reacting a compound of formula I,



wherein R<sub>1</sub>, R<sub>2</sub> and R<sub>3</sub> and x, y and z are defined as for a compound of formula II in Claim 1, with the proviso that R<sub>3</sub> is not hydrogen and R<sub>1</sub>, R<sub>2</sub>, x, y and z are the same for the starting material and the endproduct, or a corresponding stereoisomer thereof,

with a corresponding amine, followed by the protection of the hydroxyl of the former lactone ring, by reaction with a protective group forming agent, optionally in the presence of one or more suitable catalytic agents.

5. A process according to claim 4 for the preparation of a compound of formula II with R<sub>3</sub> is 2-methylbutyrate from a compound of formula I with R<sub>3</sub> is 2-methylbutylrate.

6. The process according to Claim 4 or 5, wherein the amines are selected from the group comprising:

- (1) ammonia,
- (2) primary amines, and,
- (3) secondary amines,

and the protective group forming agents are selected from the group comprising:

- (1) ketones, preferably acetone,
- (2) aldehydes,
- (3) acetals,
- (4) sulfonyl chloride, followed by oxidation with sodium periodate,

- 33 -

(5) phosphonyl chloride, followed by reaction with an alcohol, amine or water,

(6) boronic acid,

and the catalytic agents are selected from the group comprising:

(1) para-toluene sulphonic acid,

(2) sulfuric acid.

7. A process for the preparation of a compound of formula II as defined in Claim 1, with the proviso that  $R_3$  is hydrogen, and wherein both  $R_6$  and  $R_7$  may also be hydrogen or a silyl protecting group as for instance t-butyl dimethyl silyl, comprising reacting a compound of formula II as defined in Claim 1, with the proviso that  $R_3$  is not hydrogen, and wherein both  $R_6$  and  $R_7$  may also be hydrogen or a silyl protecting group as for instance t-butyl dimethyl silyl or form a borylidene moiety, and where all the parameters  $R$ ,  $x$ ,  $y$  and  $z$  are the same for the starting material and the endproduct except for  $R_3$ , with suitable reducing agents to reduce the  $R_3$  ester moiety.

8. The process according to Claim 7 wherein the reducing agents are selected from the group comprising:

(1) lithiumaluminiumhydride,

(2) aluminiumhydride,

(3) diisobutylaluminiumhydride,

(4)  $LiY$  and wherein  $Y$  is  $C_{1-6}$ alkyl or  $C_{6-14}$ aryl, preferably  $Y$  is n-butyl, and

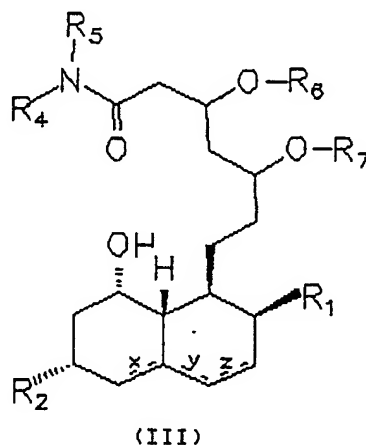
(5)  $ZMgCl$ ,  $ZMgBr$  wherein  $Z$  is  $C_{1-6}$ alkyl or  $C_{6-14}$ aryl, preferably  $Z$  is methyl.

9. A process for the preparation of a compound of formula II as defined in Claim 1, with the proviso that  $R_3$  is hydrogen, and wherein both  $R_6$  and  $R_7$  may also be hydrogen or a silyl protecting group as for instance t-butyl dimethyl silyl, comprising reacting a compound of formula II as defined in Claim 1, with the proviso that  $R_3$  is not hydrogen, and wherein both  $R_6$  and  $R_7$  may also be hydrogen or a silyl protecting group as for instance

t-butyl dimethyl silyl or form a borylidene moiety, and where all the parameters  $R$ ,  $x$ ,  $y$  and  $z$  are the same for the starting material and the endproduct except for  $R_3$  with a primary amine of the formula  $R_4NH_2$  with  $R_4$  as defined in claim 1, with the  
 5 proviso that  $R_4$  is not part of a heterocycle moiety.

10. A process for the preparation of a compound of formula II as defined in claim 1, with the proviso that  $R_3$ ,  $R_5$ ,  $R_6$  and  $R_7$  are hydrogen, and  $R_1$ ,  $R_2$ ,  $x$ ,  $y$  and  $z$  are the same for the  
 10 starting material and the endproduct, comprising reacting a compound of formula I as defined in claim 4, with an excess of a primary amine of the formula  $R_4NH_2$  as defined in claim 9 at a temperature between about  $100^\circ\text{C}$  and  $250^\circ\text{C}$ .

15 11. A process for the preparation of a compound of formula IV as defined in Claim 3, comprising reacting a compound of formula III, or the corresponding stereo isomer thereof,



wherein  $R_1$ ,  $R_2$ ,  $R_4$ ,  $R_6$  and  $R_7$  are defined as formula II in  
 20 Claim 5, and  $R_5$  is hydrogen, and with the proviso that  $R_6$  and  $R_7$  are not hydrogen, and where all the parameters  $R$ ,  $x$ ,  $y$  and  $z$  are the same for the starting material and the endproduct, with a suitable corresponding acylation agent.

12. A process for the preparation of a compound of formula II as defined in Claim 1, with the proviso that  $R_3$ ,  $R_5$ ,  $R_6$ ,  $R_7$  are not hydrogen, comprising reacting a compound of formula II wherein  $R_1$ ,  $R_2$ ,  $R_4$ ,  $R_5$ ,  $R_6$  and  $R_7$  are as defined in Claim 1 and  
5  $R_3$  is hydrogen, with the proviso that  $R_5$ ,  $R_6$  and  $R_7$  are not hydrogen, and where all the parameters  $R$ ,  $x$ ,  $y$  and  $z$  are the same for starting material and the endproduct except for  $R_3$ , with a suitable corresponding acylation agent.

10 13. The process according to Claim 8 and 9 wherein the acylation agents are selected from the group comprising:

- (1) acid chloride of the corresponding acyl group,
- (2) free acid of the corresponding acyl group.
- (3) acid anhydride of the corresponding acyl group.

15

14. A process to obtain a compound of formula I as defined in Claim 4, from formula I as defined in Claim 4, with the proviso that the  $R_3$  moiety of the compound as prepared may be different from the  $R_3$  moiety of the starting compound and where the other  
20 parameters are further the same for starting material and endproduct, comprising the following steps:

- a) ring opening of the lactone by formation of an amide bond and forming a protective group according to Claim 4,
- b) reduction of the  $R_3$  moiety of formula II according to  
25 Claim 7,
- c) acylation of the compound of formula III according to Claim 11 or a compound of formula II according to Claim 12,
- d) removal of the acetal moiety and hydrolysis of the amide group of formula IV as defined in Claim 3, or of a compound  
30 of formula II as defined in Claim 1, into formula V, wherein M forms any pharmaceutically acceptable salt, acid or ester,
- e) lactonization of formula V into formula I by heating.

35 15. A process to obtain a compound of formula I as defined in Claim 4, from formula I as defined in Claim 4, with the proviso that the  $R_3$  moiety of the compound as prepared may be different

from the  $R_3$  moiety of the starting compound and where the other parameters are further the same for starting material and endproduct, comprising the following steps:

- 5 a) reacting the compound of formula I with an amine  $R_4NH_2$  as defined in claim 9,
- b) formation of a protective group according to claim 4,
- c) acylation of the compound of formula III according to Claim 11 or a compound of formula II according to Claim 12,
- 10 d) removal of the acetal moiety and hydrolysis of the amide group of formula IV as defined in Claim 3, or of a compound of formula II as defined in Claim 1, into formula V, wherein M forms any pharmaceutically acceptable salt, acid or ester,
- e) lactonization of formula V into formula I by heating.

15

16 . A process to prepare simvastatin from lovastatin according to Claim 12, characterized by the following steps:

- 20 a) ring opening of the lactone of lovastatin by formation of an amide bond with n-butylamine, followed by dioxane forming with acetone or dimethoxypropane,
- b) reduction of the 2-methylbutyrate side chain of the compound formed in step a) by reaction with anyone of the reducing agents as defined in Claim 8,
- 25 c) acylation of the compound formed in step b) by reaction with 2,2-dimethylbutyl chloride in the presence of para-toluene sulphonic acid, hydrogen chloride or sulfuric acid.
- d) removal of the dioxane moiety and of the amide group of the compound formed in step c) by hydrolysis, optionally
- 30 followed by reaction with ammonium hydroxide to form ammonium salt of simvastatin,
- e) lactonization of the ammonium salt or sodium salt of simvastatin or by heating in toluene to form simvastatin, followed by crystallization.

35

17. A process to prepare simvastatin from lovastatin, comprising the following steps:

- 37 -

- a) ring opening of the lactone of lovastatin by formation of an amide bond with n-butylamine, followed by dioxane forming with acetone or dimethoxypropane,
- 5 b)  $\alpha$ -methylation of the 2-methylbutyrate side chain of the compound formed in step a) with methyl iodide,
- c) removal of the dioxane moiety and of the amide group of the compound formed in step a) by hydrolysis, optionally followed by reaction with ammonium hydroxide to form ammonium salt of simvastatin,
- 10 d) lactonization of the ammonium salt or sodium salt of simvastatin or by heating in toluene to form simvastatin, followed by crystallization.

18. A process for preparing simvastatin according to Claim 16  
15 or 17 from a crude lovastatin, which may contain upto about 30% of impurities, such as dihydrolovastatin or oxidized lovastatin.

Figure 1

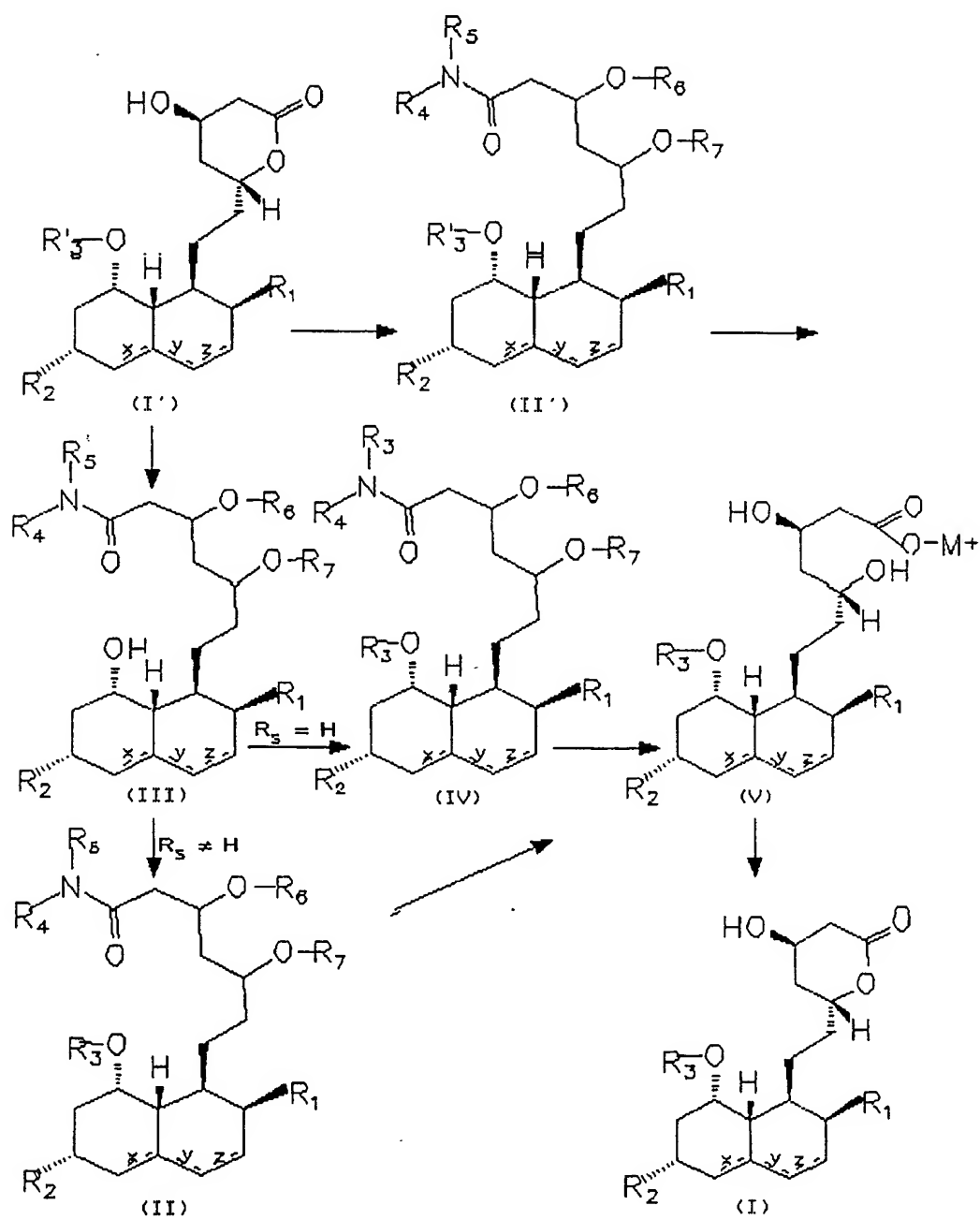
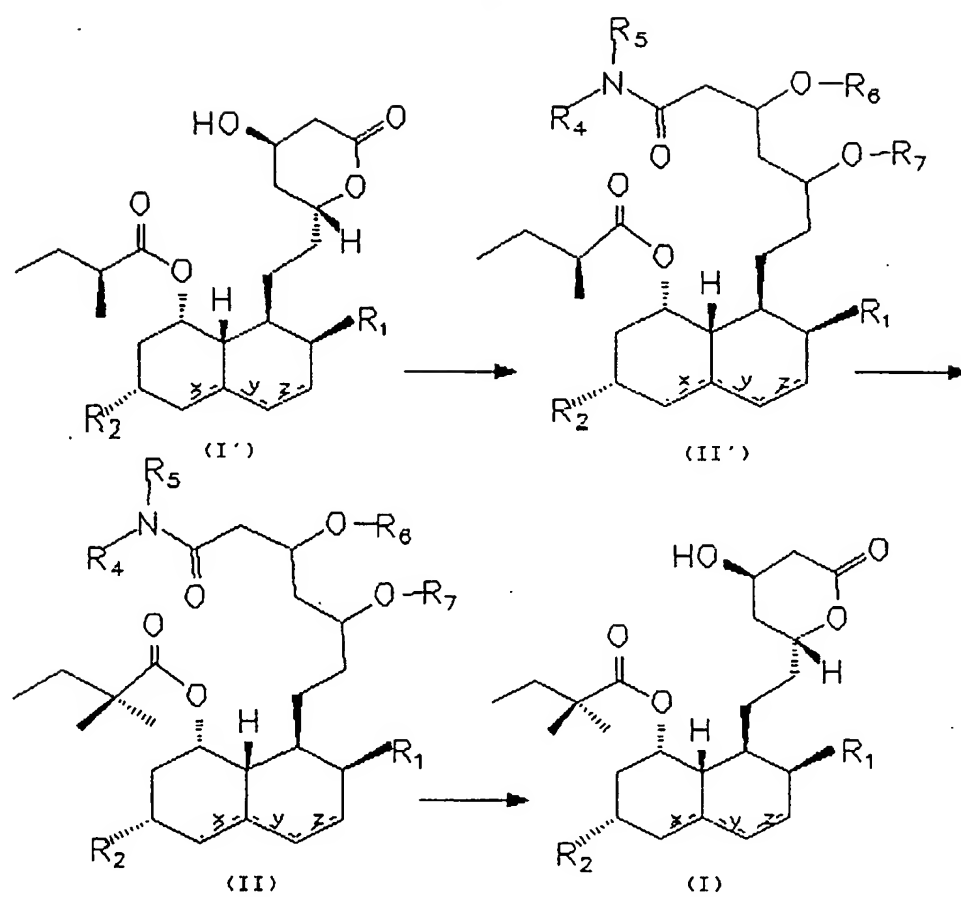




Figure 2



# INTERNATIONAL SEARCH REPORT

Int. Search No.  
PCT/EP 98/00519

## A. CLASSIFICATION OF SUBJECT MATTER

IPC 6 C07D309/30 C07C235/26 C07C235/30 C07D319/06 C07D327/10  
C07F9/6574

According to International Patent Classification (IPC) or to both national classification and IPC

## B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC 6 C07D C07C C07F

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

## C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	WO 95 13283 A (APOTEX INC) 18 May 1995 cited in the application see claims	1-18
A	ASKIN D ET AL: "SYNTHESIS OF SYNVINOLIN: EXTREMELY HIGH CONVERSION ALKYLATION OF AN ESTER ENOLATE" JOURNAL OF ORGANIC CHEMISTRY, vol. 56, no. 16, 2 August 1991, pages 4929-4932, XP000676448	1-18
A	EP 0 415 488 A (MERCK & CO INC) 6 March 1991 see claims	1-18
	-/-	

☒ Further documents are listed in the continuation of box C.

☒ Patent family members are listed in annex.

### \* Special categories of cited documents:

"A" document defining the general state of the art which is not considered to be of particular relevance

"E" earlier document but published on or after the international filing date

"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)

"O" document referring to an oral disclosure, use, exhibition or other means

"P" document published prior to the international filing date but later than the priority date claimed

"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention

"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art.

"&" document member of the same patent family

Date of the actual completion of the international search

23 April 1998

Date of mailing of the international search report

04/05/1998

Name and mailing address of the ISA

European Patent Office, P.B. 5818 Patentlaan 2  
NL - 2280 HV Rijswijk  
Tel. (+31-70) 340-2040, Tx. 31 651 epo nl,  
Fax: (+31-70) 340-3016

Authorized officer

Sánchez García, J.M.

# INTERNATIONAL SEARCH REPORT

International Application No.

PCT/EP 98/00519

## C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	<p>EP 0 299 656 A (MERCK &amp; CO INC) 18 January 1989  cited in the application  see page 1 - page 10  -----</p>	1-18

# INTERNATIONAL SEARCH REPORT

Information on patent family members

Int. oncl. Classification No

PCT/EP 98/00519

Patent document cited in search report	Publication date	Patent family member(s)	Publication date
WO 9513283 A	18-05-1995	US 5393893 A AU 8055594 A CA 2173830 A ZA 9408775 A	28-02-1995 29-05-1995 18-05-1995 10-07-1995
EP 0415488 A	06-03-1991	CA 2024248 A DE 69008277 D JP 3184940 A US 5098931 A	01-03-1991 26-05-1994 12-08-1991 24-03-1992
EP 0299656 A	18-01-1989	US 4820850 A AU 604937 B CA 1287063 A CN 1031086 A,B CY 1613 A DK 380788 A FI 883184 A,B, HK 98991 A IE 61025 B JP 1070481 A JP 1988037 C JP 7017663 B JP 2527535 B JP 7196641 A KR 9509314 B PT 87909 A,B ZA 8804924 A	11-04-1989 03-01-1991 30-07-1991 15-02-1989 10-07-1992 15-02-1989 11-01-1989 13-12-1991 07-09-1994 15-03-1989 08-11-1995 01-03-1995 28-08-1996 01-08-1995 19-08-1995 30-06-1989 17-01-1989